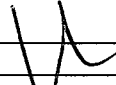


Date: Friday, 15/02/2008 7:17:49 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 37371		
Estimate Number	: 10845		
P.O. Number	:	Part Number	: D32833
This Issue	: 15/02/2008 S.O. No. :	Drawing Number	: D3283 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: E
Previous Run	: 37371	Material	:
Written By	: 	Due Date	: 22/02/2008 Qty: 40 Um: Each
Checked & Approved By	:		
Comment	: Est A 04/09/28 New issue KJ/JLM Est Rev:B As per Rev E 07-09-09 JLM Verified By:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S080	6061-T6 .080 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.3465 sf(s)/Unit Total: 13.8600 sf(s)  
 6061-T6 .080 Sheet  
 Material: 6061-T6 (QQ-A-250/11) 0.080" thick  
 (M6061T6S.080)  
 Identify for D3283-3

Batch: 106320 18 8-2-15

2.0	SHEAR	SHEAR
-----	-------	-------

REV E 18 8-2-15  
E

(40)

Comment: SHEAR

Cut blanks: 15.550" x 2.450

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per Foto FA424 and Dwg D3283  
 Stack of 10  
 Identify as D3283-3

W. Alan Jett  
EOLIB 18 8-2-15  
Dwg D3283

(40)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------

18 8-2-15

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5 05/02/18 +40 coentus

Date: Friday, 15/02/2008 7:17:49 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 37371

Part Number: D32833

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr

Done at DCB # 3.0 08/02/19

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/19 (40)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

BR 08-02-20

(40)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/02/20

(40)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: 177

8/2/21

sq

(40x)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/20

(40)

Job Completion



2008/2/21

(40)

h

Date: Monday, 2/11/2008 2:15:11 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 37371	
Estimate Number : 10845	
P.O. Number :	Part Number : D32833
This Issue : 2/11/2008 S.O. No. :	Drawing Number : D3283 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 26793	Material :
Written By : <u>                    </u>	Due Date : 3/10/2008 Qty: 40 Um: Each
Checked & Approved By : <u>                    </u>	
Comment : Est A 04-09-28 New issue KJ/JLM	
Est Rev:B As per Rev E 07-09-09 JLM Verified By:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S080	6061-T6 .080 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.3465 sf(s)/Unit Total : 13.8600 sf(s)  
 6061-T6 .080 Sheet  
 Material: 6061-T6 (QQ-A-250/11) 0.080" thick  
 (M6061T6S.080)  
 Identify for D3283-3

Batch:                     

2.0	SHEAR
-----	-------



SHEAR

Comment: SHEAR

Cut blanks: 15.550" x 2.450

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA424 and Dwg D3283  
 Stack of 10  
 Identify as D3283-3

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 2:15:11 PM  
User: Kim Johnston

## Process Sheet

✓ Customer: CU-DAR001 Dart Helicopters Services Drawing Name: DOUBLER

Job Number: 37371

Part Number: D32833

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

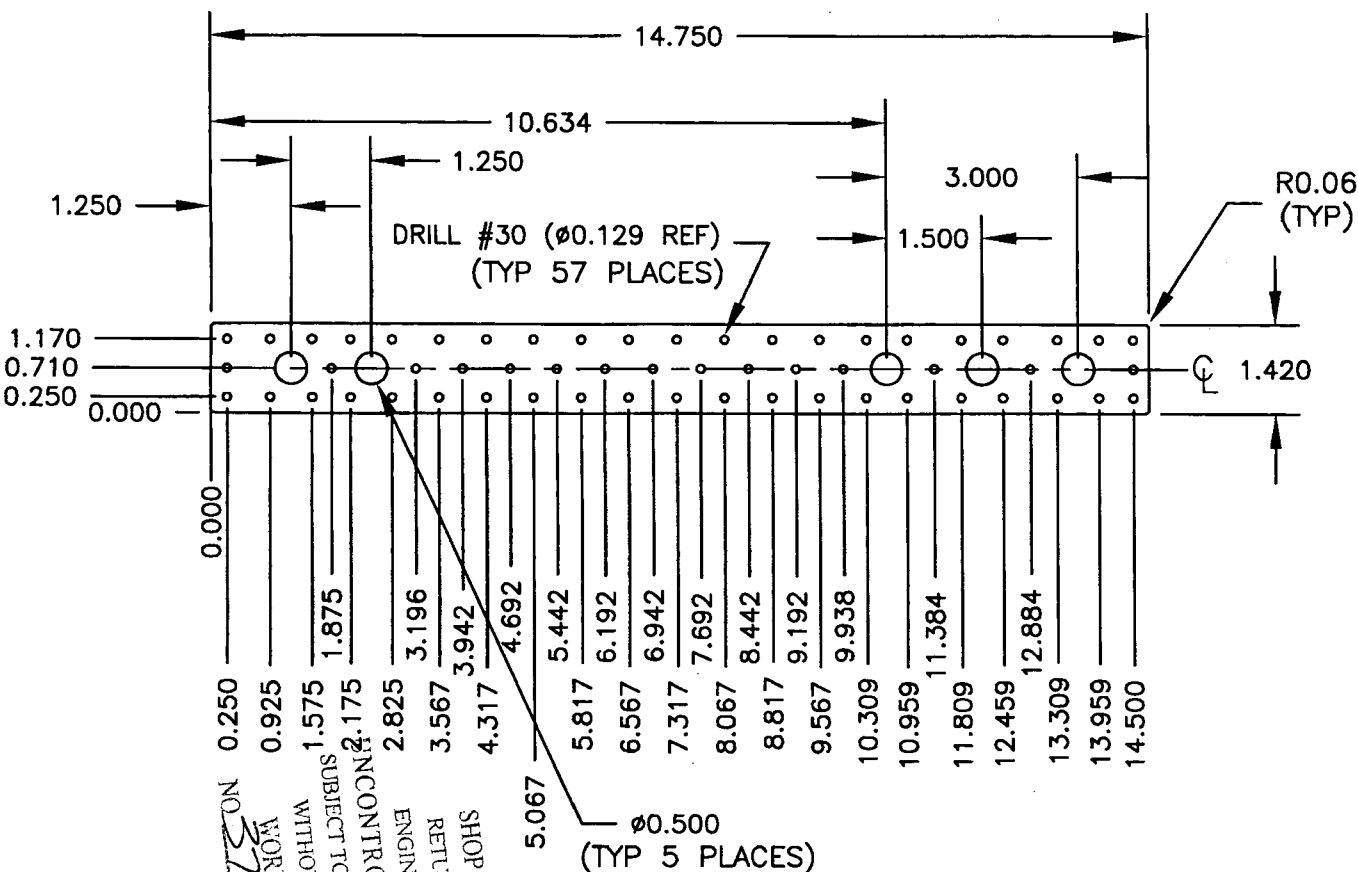
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

RELEASED  
07-08-2014  
PER ECN 959

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
		PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D3283	SHEET 1 OF 2
DATE		TITLE	SCALE
07.06.01		DOUBLER	1:3
A	04.05.06	NEW ISSUE	
B	04.08.09	10.882 WAS 11.502	
C	05.03.16	CHANGE HOLE PATTERN FOR -1	
D	05.08.09	REDESIGN	
E	07.06.01	MISSING HOLE ADDED @ (7.692, 0.710)	



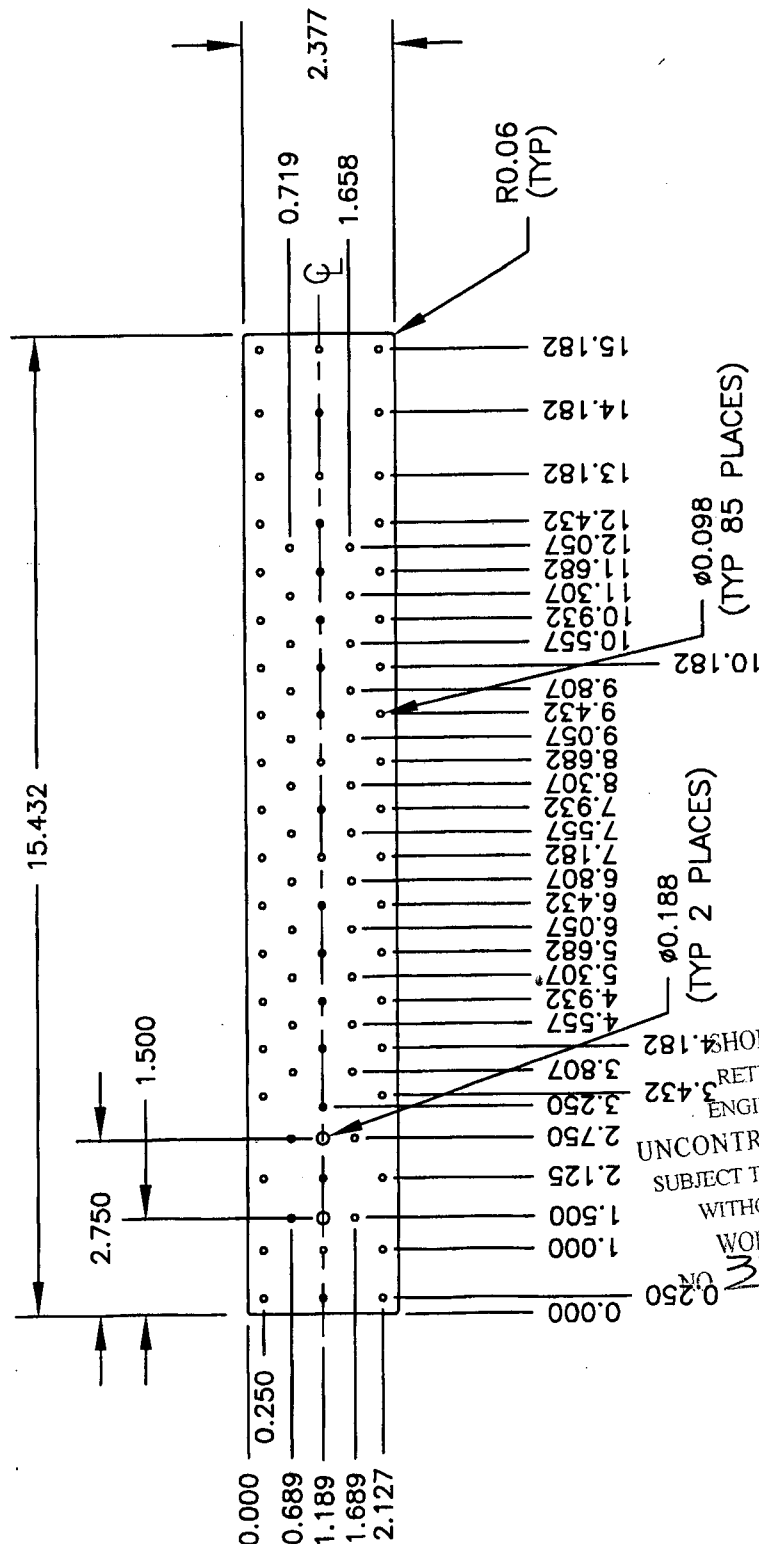
**D3283-1 DOUBLER**

- 1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

**DART**

DESIGN <b>99</b>	DRAWN BY <b>DC</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <b>B</b>	APPROVED <b>[Signature]</b>	DRAWING NO. D3283	REV. E SHEET 2 OF 2
DATE 07.06.01		TITLE DOUBLER	SCALE 1:3

**RELEASED**  
07.08.2004  
PER ECN 959



**D3283-3 DOUBLER**

- 1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD		Work Order: 37371
Description: DOUBLER		Part Number: D3283-3
Inspection Dwg: D3283-3 Rev: E		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.100	X			
Ø .188	+ .005 - .001	.190	*			
.250	+/- .010	.250	*			
.689	+/- .010	.689	*			
1.189	+/- .010	1.189	*			
1.689	+/- .010	1.689	*			
2.127	+/- .010	2.127	*			
.719	+/- .010	.719	*			
1.658	+/- .010	1.658	X			
2.377	+/- .010	2.379	X			
2.750	+/- .010	2.750	*			
1.500	+/- .010	1.500	*			
.250	+/- .010	.250	X			
1.000	+/- .010	1.000	*			
1.500	+/- .010	1.500	X			
2.125	+/- .010	2.125	*			
2.750	+/- .010	2.750	*			
3.250	+/- .010	3.250	*			
3.432	+/- .010	3.432	*			
3.807	+/- .010	3.807	X			
4.182	+/- .010	4.182	*			
4.557	+/- .010	4.557	*			
4.932	+/- .010	4.932	X			

Measured by: IB
Date: 8-2-15

Audited by: J
Date: 08/02/15

Prototype Approval: n/a
Date: 12

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	37371
Description: DOUBLER		Part Number:	D3283-3
Inspection Dwg: D3283-3 Rev: F		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.307	+/- .010	5.307	X			
5.682	+/- .010	5.682	X			
6.057	+/- .010	6.057	X			
6.432	+/- .010	6.432	X			
6.807	+/- .010	6.807	X			
7.182	+/- .010	7.182	X			
7.557	+/- .010	7.557	X			
7.932	+/- .010	7.932	X			
8.307	+/- .010	8.307	X			
8.682	+/- .010	8.682	X			
9.057	+/- .010	9.057	X			
9.432	+/- .010	9.432	X			
9.807	+/- .010	9.807	X			
10.182	+/- .010	10.182	X			
10.557	+/- .010	10.557	X			
10.932	+/- .010	10.932	X			
11.307	+/- .010	11.307	X			
11.682	+/- .010	11.682	X			
12.057	+/- .010	12.057	X			
12.432	+/- .010	12.432	X			
13.182	+/- .010	13.182	X			
14.182	+/- .010	14.182	X			
15.182	+/- .010	15.182	X			
15.432	+/- .010	15.432	X			

Measured by:	LB
Date:	8-2-15

Audited by:	
Date:	

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	